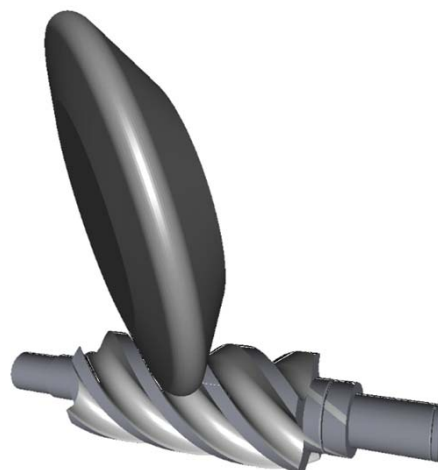










Compressor Rotor Ø116 Z5

A30-200

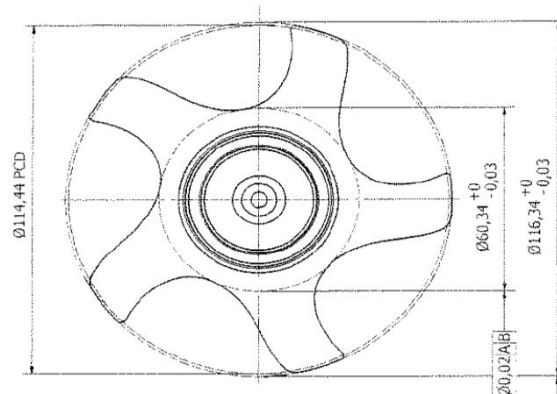
Material removal in Pregrinding is 0.03 mm per pass, total removal 1 mm. For finishing 5 passes with partial increment of 0.005 mm are executed.



1. Cycletime for Production

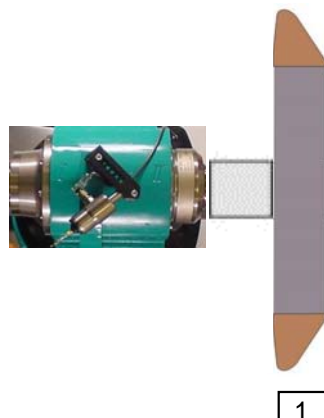
Workpiece: Ø 116 mm, Z 5, Length 225 mm, Helix 338 mm Material GGS				
Operations				
Feed [mm/Min]	150	2000	150	3000
Power [kW]	3	25	3	20
Cutting feed [m/s]	34	34	34	34
Used wheels				
Grinding time [s]	164	2991	164	910
Total cycle time	70 Min 29			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	DXF Ø450-500 C80
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3. Machine and Software Requirements

Machines:	5 axes CNC grinders : CORVUS C500	Coolant:	Synthetic Oil, pressure 16 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Dressing Unit		
Responsible engineer:	OP. 3.8.10		

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
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